

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003524**Date Inspected:** 06-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	n/a	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Plate Material Storage Yard (check samples):

Quality Assurance (QA) Inspector Brannon received plate material list for Caltrans check test samples, plate list No. 309 (120th batch), No. 310 (122th batch), No. 311, 312 & 313 (1234d batch), No. 314 (126th batch), No. 315 & 316 (128th batch), No. 317, 318, 319 & 320 (132nd batch), and No. 321 (136th batch), received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC plate material storage yard accompanied by ZPMC Quality Control Miss. Zhu Weijuan. QA Inspector Brannon verified, plate ID #, Grade, Batch # and material test reports. QA Inspector Brannon wrote lot numbers and marked the direction of rolling on each of the 13 samples. Caltrans lot numbers for check samples are as follows.

No. 309, ID#WY070306Q114, Grade A709M-345T2-X, Heat No.7100746N , MTR No. 300,

Remarks-Shell Plate, Lot No. B22-061-08

No. 310, ID#WY070516Q082, Grade A709M-345T2-x-S, Heat No. 7100661N, MTR No. 11156,

Remarks-Shell Plate, Lot No. B22-062-08.

No. 311, ID#WY070906Q026, Grade A709M-345F2-X, Heat No. 7301585N, MTR No. 11437,

Remarks-SPCM, Lot No. B22-063-08.

No. 312, ID#WY070906Q2008, Grade A709M-345F2-X, Heat No. 7301482N, MTR No. 11446,

Remarks-SPCM/Shell Plate, Lot No. B22-064-08.

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No. 313, ID#BS080113A018, Grade A709M-345F2-X, Heat No. 07301485N0, MTR No. 11455,
Remarks-SPCM, Lot No. B22-065-08.

No. 314, ID#WY070726Q078, Grade A709M-345T2-X, Heat No. 07302292N0, MTR No. 12053,
Remarks-Shell plate, Lot No. B22-066-08.

No. 315, ID#WY070826Q004, Grade A709M-345T2-X, Heat No. 07302353N, MTR No. 12248,
Remarks-Shell plate. Lot No. B22-067-08.

No. 316, ID#WY070906Q262, Grade A709M-345T2-X, Heat No. 07301494N0, MTR No. 12343,
Remarks-Shell Plate. Lot No. B22-068-08.

No. 317, ID#NG071209G008, Grade A709M-345F2-X, Heat No. 07208335, MTR No. 12472,
Remarks-SPCM. Lot No. B22-069-08.

No. 318, ID# NG071203G152, Grade A709M-345F2-X, Heat No. 07108201, MTR No. 12472,
Remarks-SPCM/Shell Plate. Lot No. B22-070-08.

No. 319, ID# NG071203G155, Grade A709M-345F2-X, Heat No. 07208336, MTR No. 12472,
Remarks-SPCM. Lot No. B22-071-08.

No. 320, ID# NG071129G070, Grade A709M-345F2-X, Heat No.07108202, MTR No. 12482,
Remarks-SPCM, Lot No. B22-072-08.

No. 320, ID# WY070716G217, Grade A709M-345F2-X, Heat No.7301480N, MTR No. 11275,
Remarks-SPCM, Lot No. B22-073-08.

The above lot numbers were written on the each check sample along with an arrow showing the direction of rolling. The lot numbers, date, batch/heat numbers, plate type/grade and plate thickness were all entered on the Caltrans check sampling tracking log for Caltrans Project 04-0120F4.

Summary of Conversations:

No relevant conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
